



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3183-041
Job Sheet 198443



Part No: D3183-041

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/3/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs	9/3/19	9/3/19	0.00	0.01	Bandsaw - 1		SBL 19/08/18
110	HAAS 4 Axis - B4B	2 pcs	9/3/19	9/3/19	1.00	10.15	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/08/18
							HAAS - 4 - B4B		
120	QC 2	2 pcs	9/3/19	9/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/08/19
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S206769



Part: D3183 - 041

Job No: 198443

Serial No/Batch: S206769

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/19/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130 QC 8	2 pcs	9/3/19	0.00	0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.e 19-08-21
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140 Small Fab - 2 - B4B	2 pcs	9/3/19	0.00	0.11	Small Fab - 1 - B4B	SMB
					Small Fab - 2 - B4B	19/8/22
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150 QC 5	2 pcs	9/3/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 40
					QC 5 - 61	AUG 27 2019 9-59
					QC 5 - 81	
160 Packaging 3-1 - Stock - B4B	2 pcs	9/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	

					Packaging 3 - 4 - B4B	NL	STO20
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
170 QC 21 - SA	2 pcs	9/3/19	0.00	0.00	QC 21 - SA - 21	AUG 23 2019	DAS 77 9-89
					QC 21 - SA - 70		DAS 70 9-89
					QC 21 - SA - 53		
Part Op 100 - (Bandsaw) Cut blanks: (1.500" x 2.000") 4.300" long Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3183-1 as per Folio FA320 and Dwg D3183 Identify as D3183-1 2- Deburr 3-Scribe batch number 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - (Small Fab) Assemble D3183-041 as per Dwg D3183. 150 - QC5- Inspect part completeness to step on W/O 160 - Identify as per dwg & Stock Location: 170 - QC21- Final Inspection - Work Order Release							
Job BOM							
Job BOM records could not be found.							
Job Allocations							
Job Allocations could not be found.							

Part Specifications

Specifications could not be found.

Plex 7/29/19 1:20 PM Dart.Renwick.Jennifer

M17-4-B 2,000x1,500 op 100 qty. each 0,3594/pc
- D3121-01 op 140 qty. each 2PCS
- D3183-045 op 140 qty. each 2PCS

DAS
35
9-89

STO18 5172048
STO21 5150233
STO21 5197528

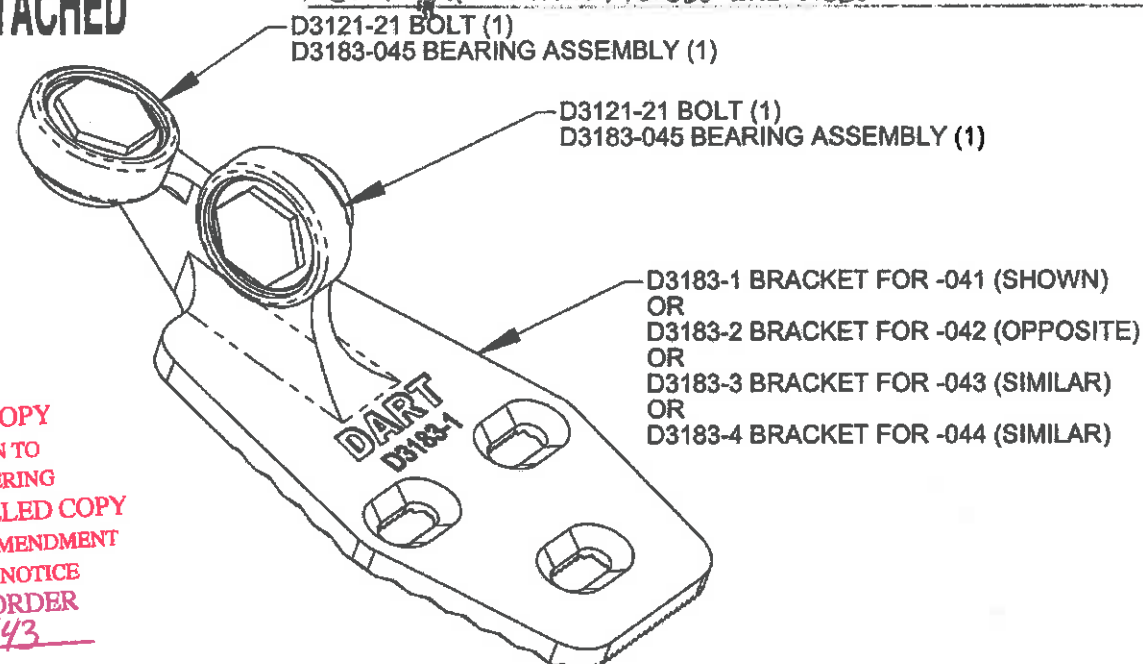
DART

10 COPY ISSUED

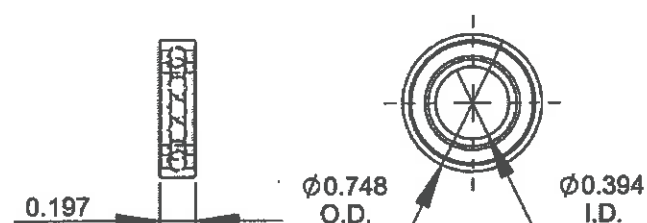
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198443

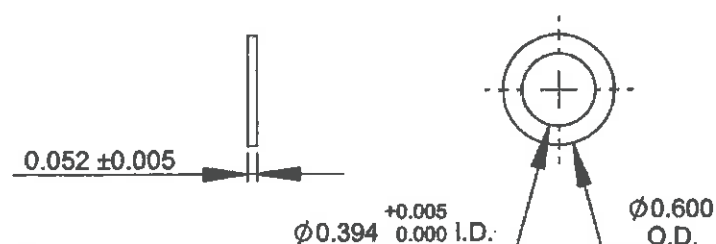


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

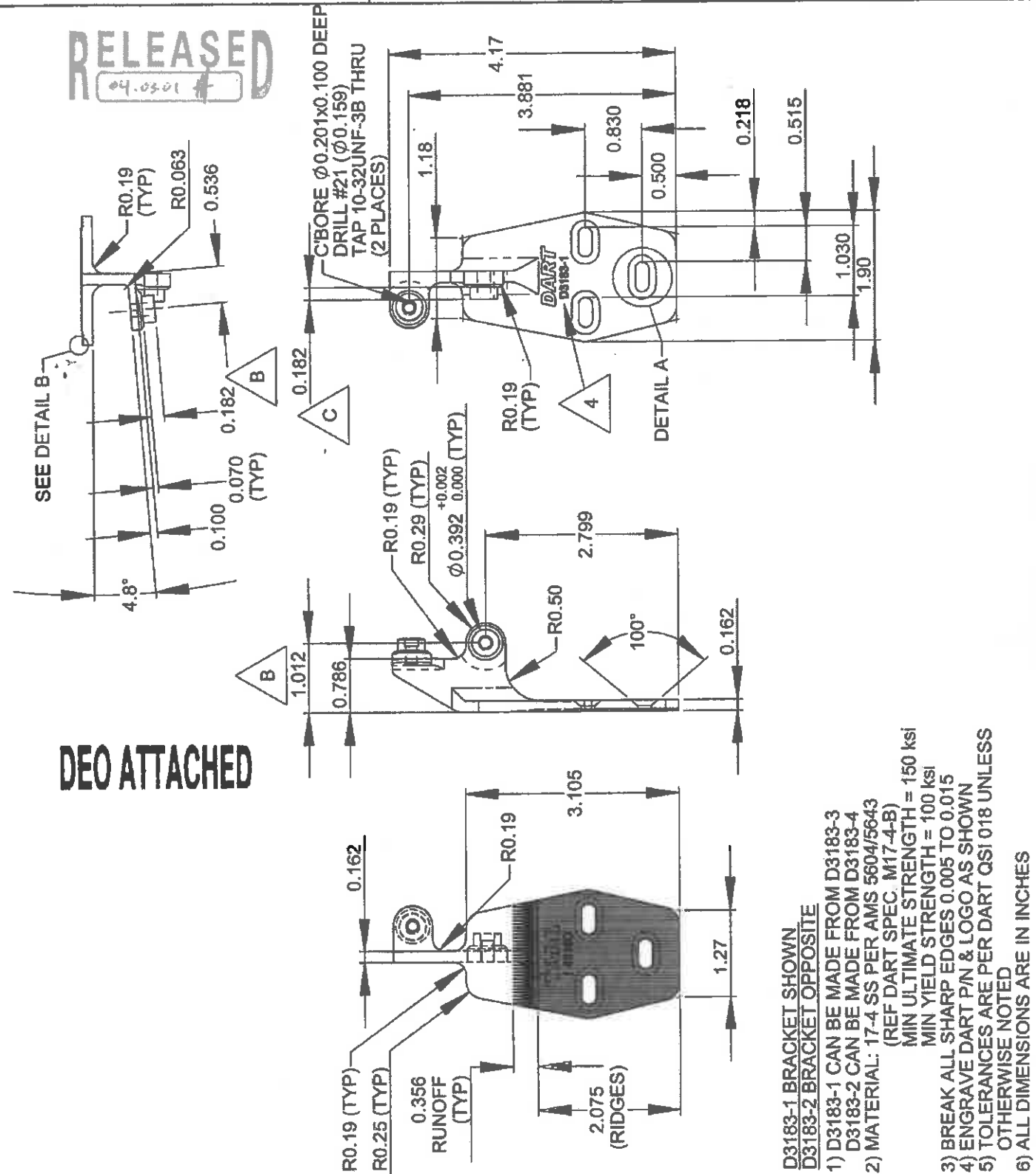
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 2 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



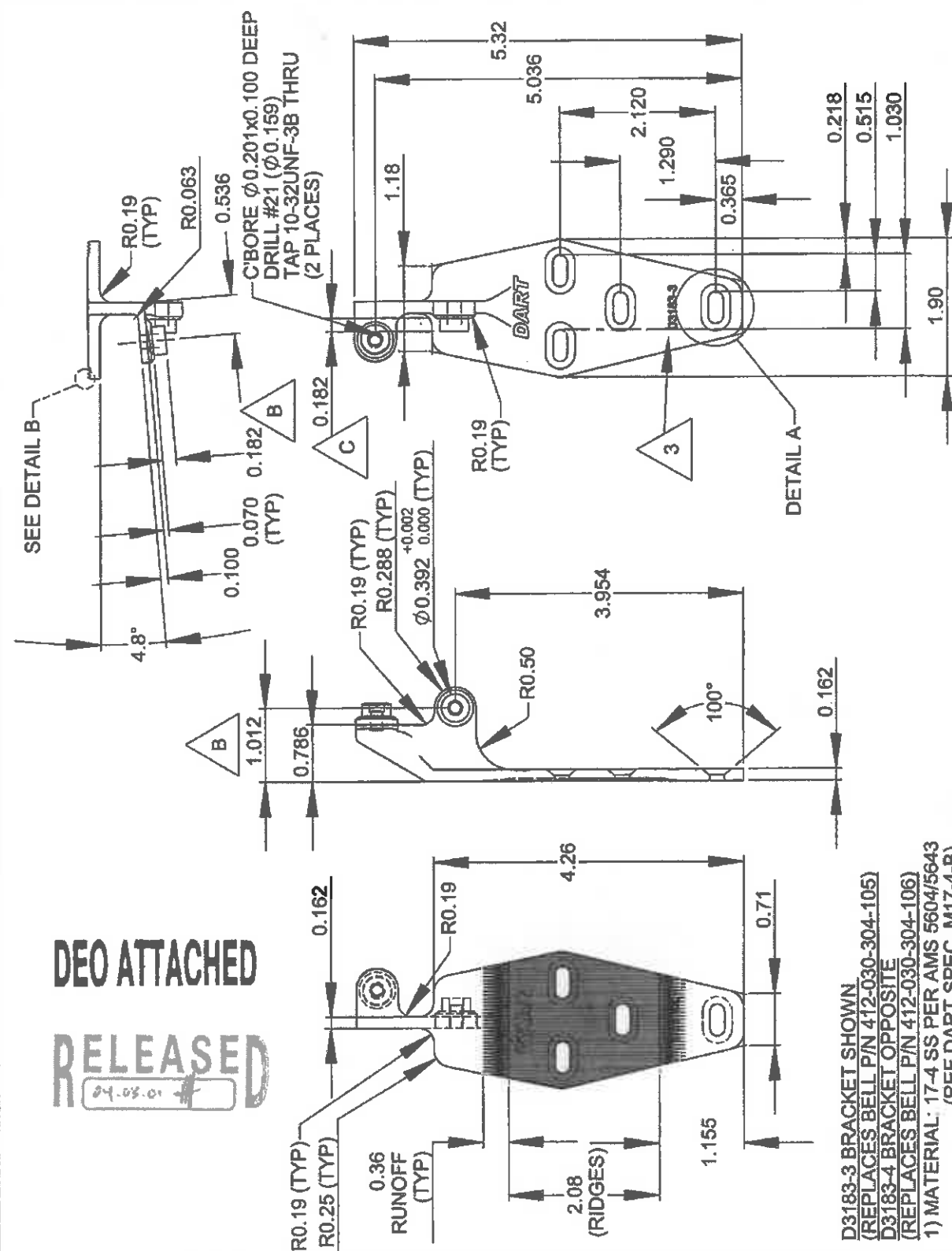
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DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)
1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

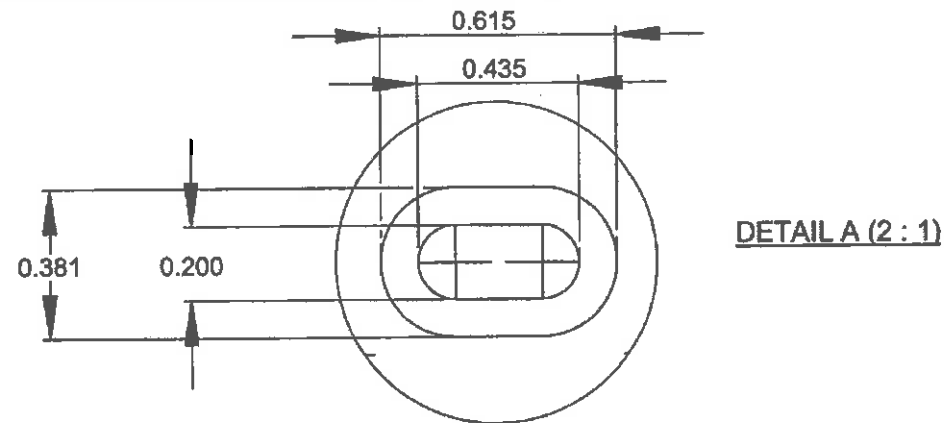
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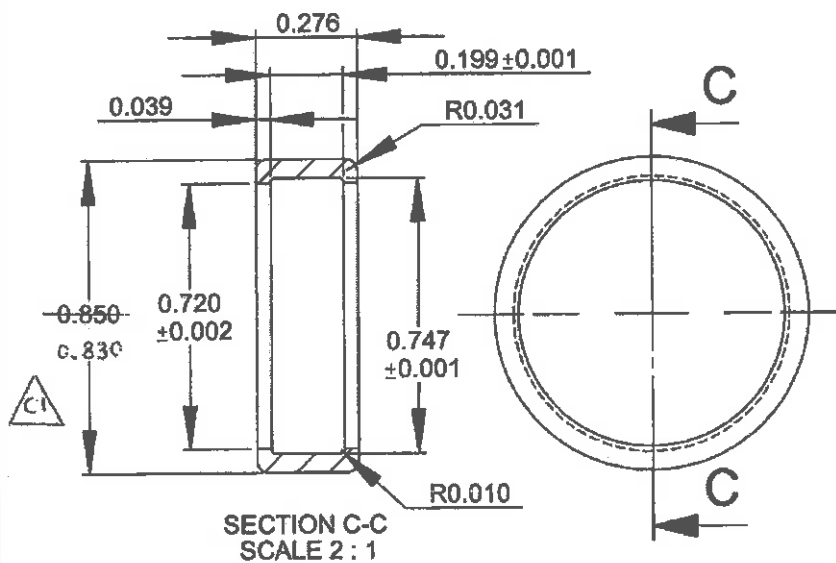
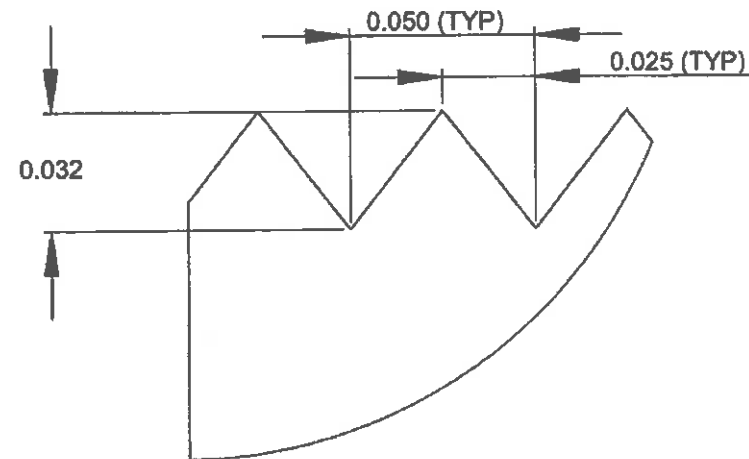


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



RELEASED
04.03.01
DEO ATTACHED

DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV/C1	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN P	CHECKED J	MFG. APPR. M	APPROVED MP	DE APPR. M		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
WD

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ART AEROSPACE LTD		Work Order:	198443
Description: Bracket		Part Number:	D3183-1
Inspection Dwg: D3183 Rev: C1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010					
0.182	+/-0.010	.182	✓		Vern	SEP-05
0.070	+/-0.010	.069	✓		"	
0.100	+/-0.010	.099	✓		"	
R0.063	+/-0.010	.063	✓		RG	
R0.189	+/-0.010	.188	✓		RG	
3.881	+/-0.010	3.883	✓		HG	3/006
4.17	+/-0.030	4.171	✓		HG	↓
0.830	+/-0.010	.830	✓		HG	
0.500	+/-0.010	.500	✓			
0.218	+/-0.010	.214	✓			
1.030	+/-0.010	1.031	✓		HG	3/006
1.90	+/-0.030	1.890	✓			
1.012	+/-0.010	1.014	✓			
0.786	+/-0.010	.780	✓		HG	3/006
R0.19	+/-0.010	.188	✓		RG	
Ø0.392	+0.002/-0.000	.1936	✓			
0.162	+/-0.010	.166	✓			
2.799	+/-0.010	2.803	✓		HG	3/006
2.075	+/-0.010	2.075	✓		Vern.	SEP-05
0.162	+/-0.010	.163	✓		mic.	
0.032	+/-0.010	.028	✓			
0.381	+/-0.010	.380	✓			
0.200	+/-0.010	.200	✓			

Measured by: SBL	Audited by: B.e	Prototype Approval:	N/A
Date: 19/08/18	Date: 19-08-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3183-041/-042)	KJ/JLM	